

2

Split

cut Friday

Work Order ID 144716 - 2

144716

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April 22, 2016 12:39:57 PM

Item ID: D2432 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bearpaw 19" X 24"
Start Date: 5/13/2016 Start Qty: 16.00 *16* ~~10/12~~ JH Cust Item ID:
Required Date: 5/20/2016 Req'd Qty: 16.00 *16* 10/12 Customer:
Reference:

Approvals: Process Plan: SU Date: 160421 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2432	H
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120

120

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

Cut Blank as per D2432 File

0.00

2.40

15 12/05/31

130

130

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

0.56

7.20

12 1666

140

140

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.16

12 1666

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			
		OTHER : _____							

Work Order ID 144716

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144716

Page 2

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Bearpaw 19" X 24"
 Start Date: 5/13/2016 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 5/20/2016 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.32				12	10		DAS 14 9-89 16/06/07
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>St</u> Memo	0.00 0.16				12	DAS 6 9-89		JUN 07 2016
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.60				MCS			JUN 07 2016 MCS

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 144716

144716

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	60.2330	3.7	59.2			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

on 16/05/16

Location

Loc Qty

Loc Code

MAT

29.9

m134171

29.9

MAT018

30.333

m131661

1.473

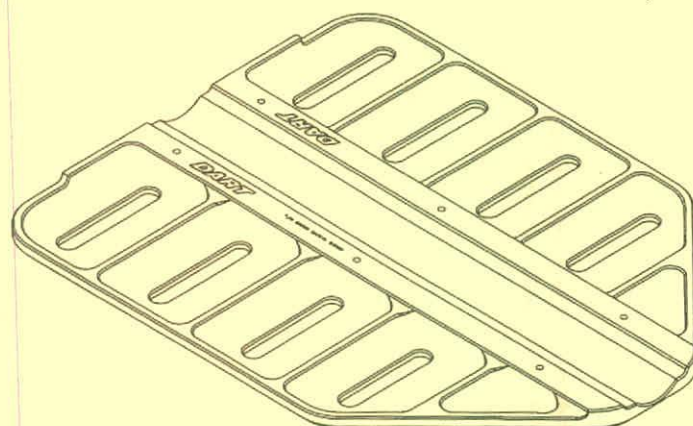
m134372

28.86

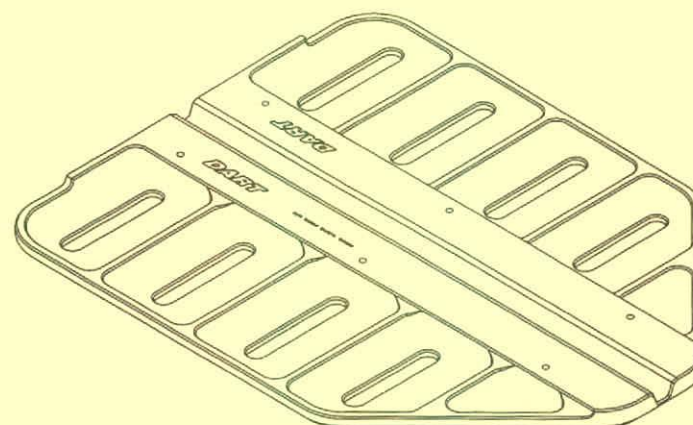
134823

60





D2432F BEARPAW

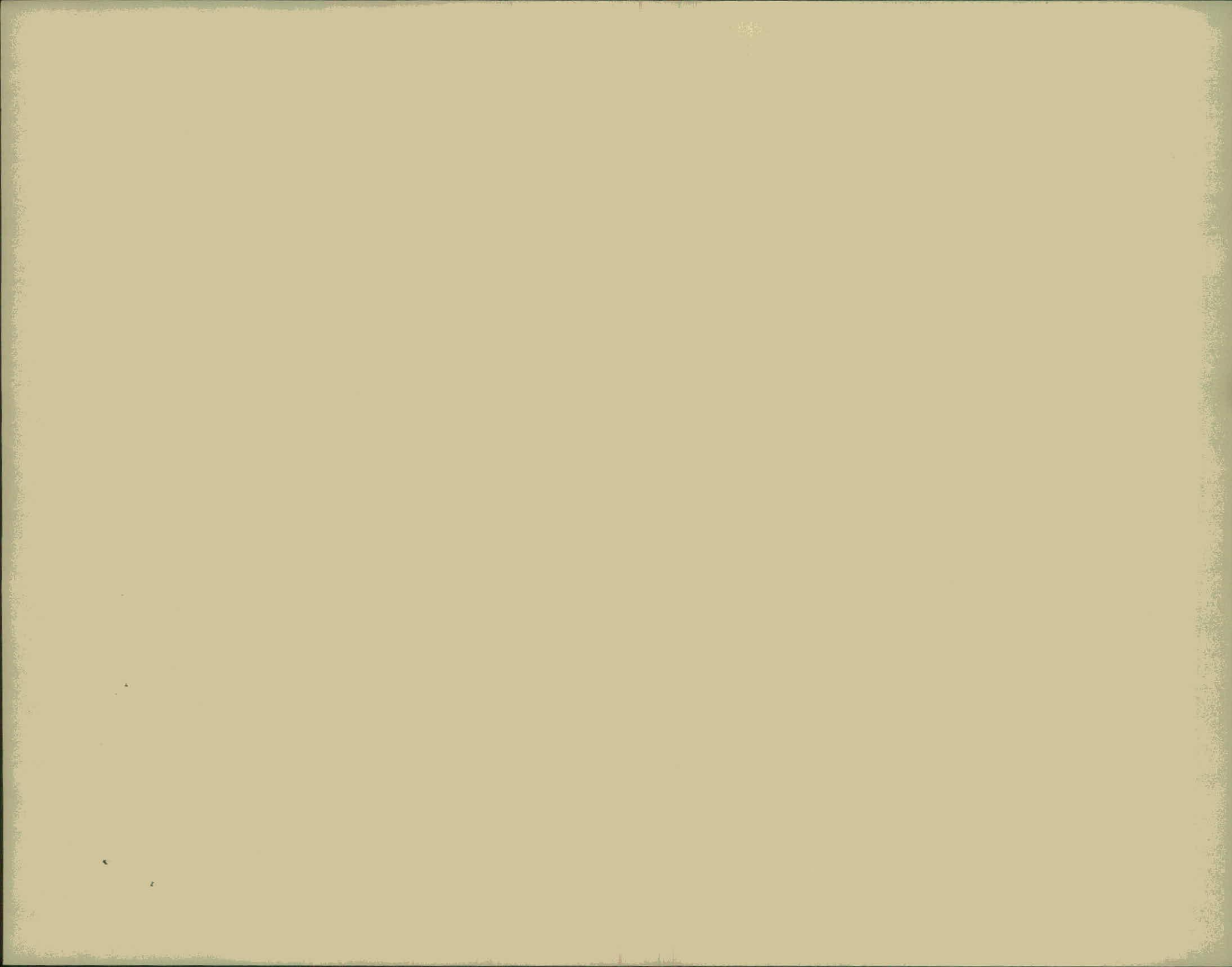


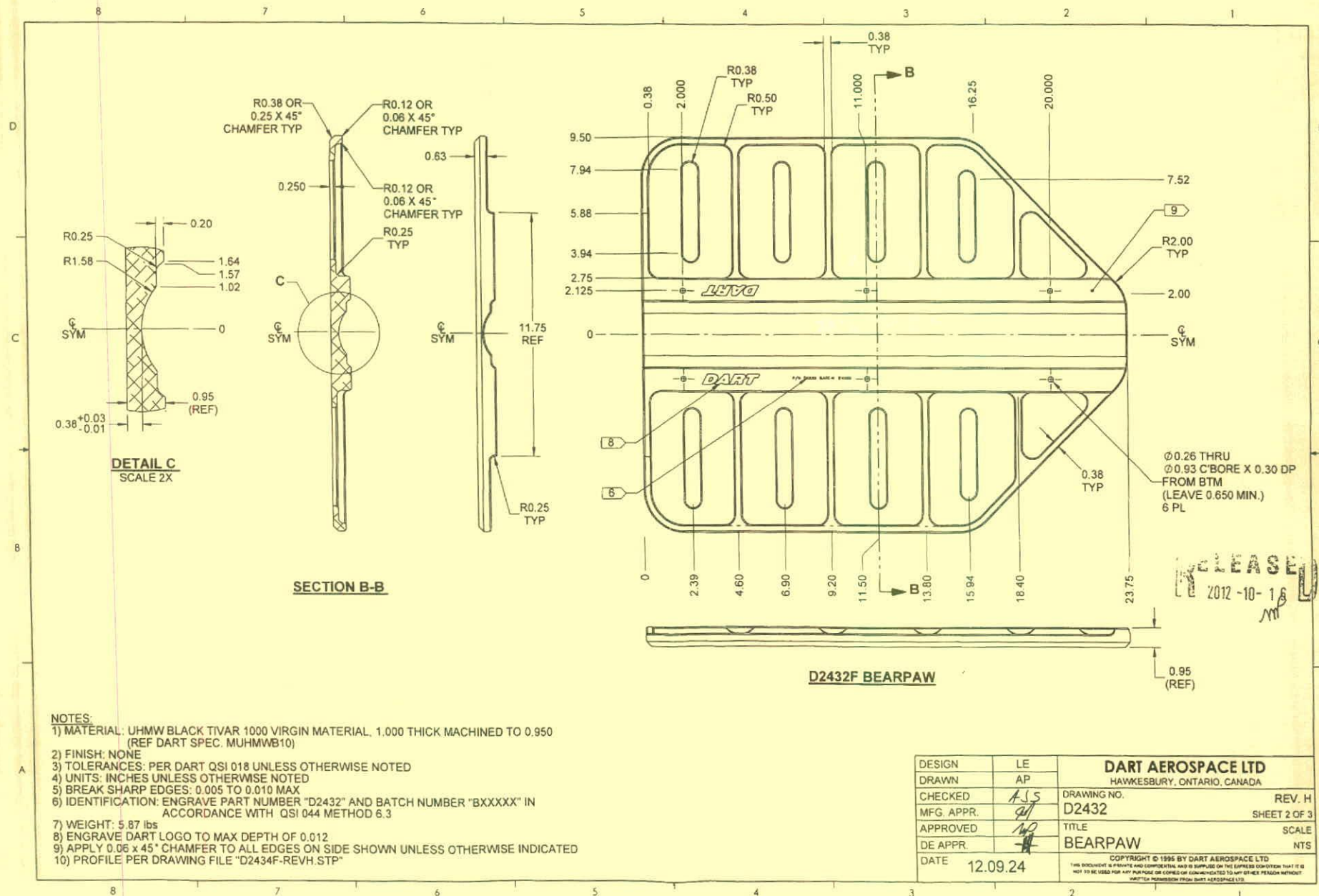
D2432-3 BEARPAW

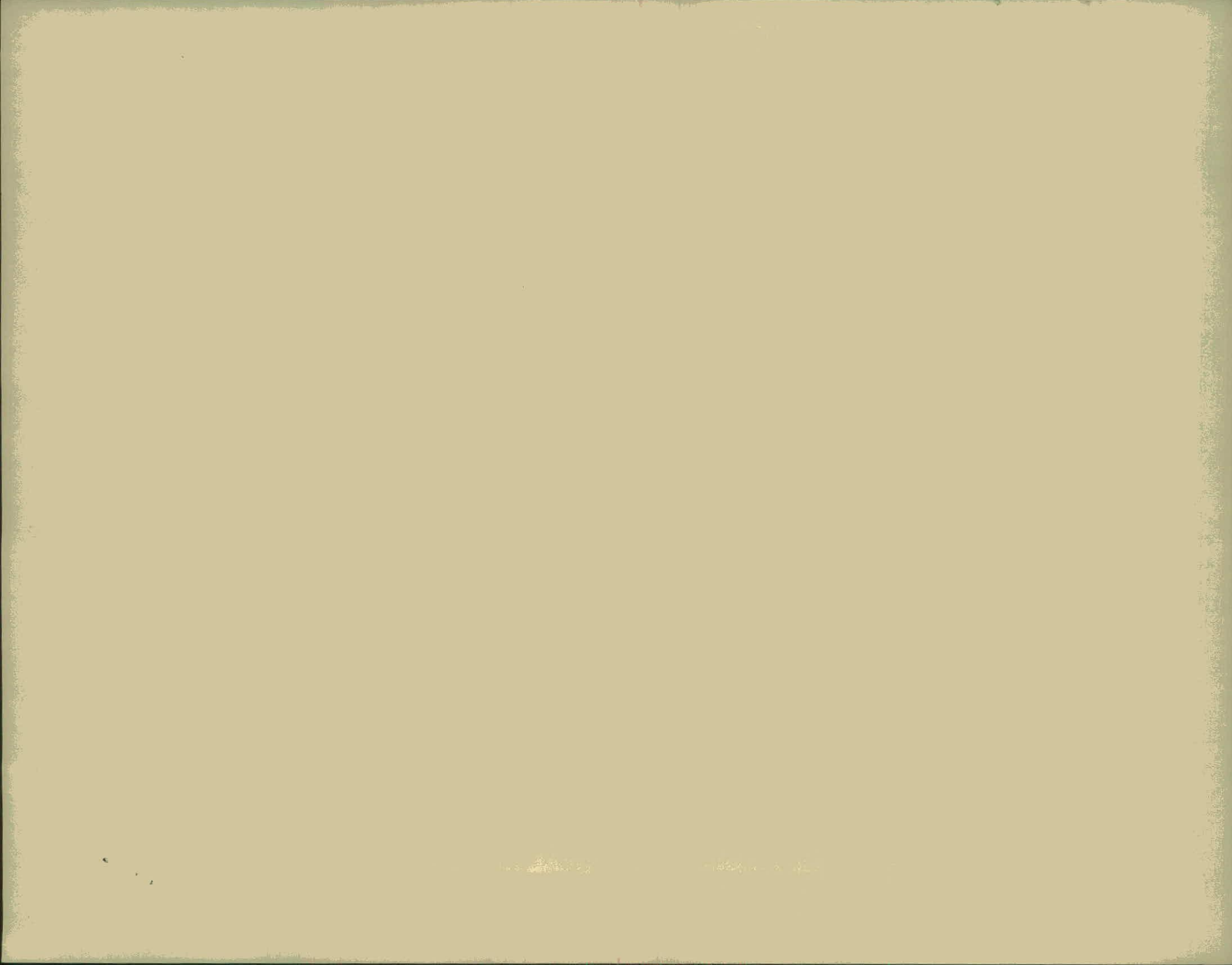
20160429
 2012-10-16
 RELEASED
 144716

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2432 TITLE BEARPAW SCALE NTS	
DRAWN	AP		
CHECKED	ASS		
MFG. APPR.	21		
APPROVED	140		
DE APPR	140	REV. H SHEET 1 OF 3 DATE 12.09.24	
DATE	12.09.24		

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DART AEROSPACE LTD		Work Order: 144716
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	/		VERA	SL-10
B	0.200	+/-0.030	0.200	/			
C	0.25 x 45°	+/-0.030	0.25 x 45°	/			
D	R0.250	+/-0.030	R.250	/			
E	0.250	+/-0.010	0.253	/			
F	0.625	+/-0.030	0.632	/			
G	0.375	+0.030/-0.010	0.385	/			
H	0.950	+/-0.030	0.960	/			
I	19.000	+/-0.030	19.00	/			
J	Ø0.260	+0.005/-0.000	0.260	/			
K	Ø0.93	+/-0.030	0.930	/			
L	0.30	+0.030/-0.000	0.315	/			
M	23.750	+/-0.030	23.750	/		M-TAPE	
N	2.000	+/-0.030	2.001	/			
O	0.38	+/-0.030	0.381	/			
P							
Q							
R							
S							
T							
U							
V							

Measured by: J	Audited by: DAS	Preliminary Approval:
Date: 16-6-5	Date: 16/06/07	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	

